

shg April 23

Work Order ID 82733

April-05-12 12:56:43 PM

82733

Page 1

Item ID: D3327-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Basket Lid Assembly

Stop *NS2*

Start Date: 05/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 20/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLS

Date: 12/04/05 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3327

Rev B

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut tubes as per Dwg D3327

1x ~~Ø~~ 12.04.17

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

1x ~~Ø~~ 12.04.18

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

8/2/2018

Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00

130

Powdercoat

Powder Coating

Memo

0.00

1ST COAT:

START TIME: 12:00

OVEN TEMPERATURE: 400°F

FINISH TIME: 12:30

***** 2nd coat if necessary *****

2ND COAT:

START TIME: 12:45

OVEN TEMPERATURE: 400°F

FINISH TIME: 1:15

140

QC3- Inspect Part Finish

0.00

140

QC

Quality Control

Memo

0.00

M121134

IX ~~Ø~~ Mf 12/04/18

1 ~~Ø~~ 12-4-18

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Page 3

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Required Date: 20/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location: *GA*

0.00

150

Packaging

Memo

W/O 82730

0.00

Packaging

IX

Ø

12/04/12

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/4/12

120419

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

April-05-12 12:56:46 PM

Page 1

Work Order ID: 82733

82733

Parent Item: D3327-041

D3327-041

Parent Item Name: Basket Lid Assembly

Start Date: 05/04/2012

Required Date: 20/04/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A05.02.09New issueKJ/JLM
IPP Rev:B 08-12-16 attach DEO DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NTS0.500W.035		Purchased	No			100	f	311.2976	14.5	15.26316			

M4130NTS0 500W 035

4130 Square tube .500 x .500 x .035w

**

dy 12.04.16

Location

Loc Qty

Loc Code

MAT034

311.2976

109127

87.4767

109385

15.75

112786

17.6261

119441

8.8248

119506

36.34

119683

145.28

15.26

D3328-1

Manufactured No

100

Each

11.0000

2

2

D3328-1

Basket Hinge

**

dy 12.04.16

Location

Loc Qty

Loc Code

WA005

11

33871

11

100

Each

16.0000

2

2

D3349-1

Manufactured No

D3349-1

Spacer Bushing

**

dy 12.04.16

Location

Loc Qty

Loc Code

WA005

16

44401

16

21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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April-05-12 12:56:46 PM

Page 2

Work Order ID: 82733

Parent Item: D3327-041

Parent Item Name: Basket Lid Assembly

82733

D3327-041

Start Date: 05/04/2012

Required Date: 20/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3352-1

Manufactured No

100

Each

8.0000

1

1

D3352-1

Label Plate

**

SD 12.04.16

Location

Loc Qty

Loc Code

WA005

8

41925

8

D3367-1

Manufactured No

100

Each

13.0000

2

2

D3367-1

Mounting Bracket

**

SD 12.04.16

Location

Loc Qty

Loc Code

WA005

13

76500

13

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

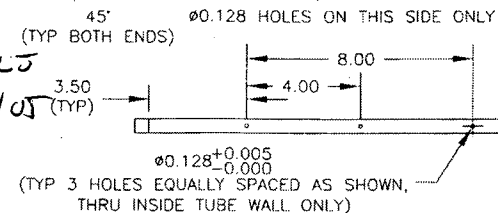
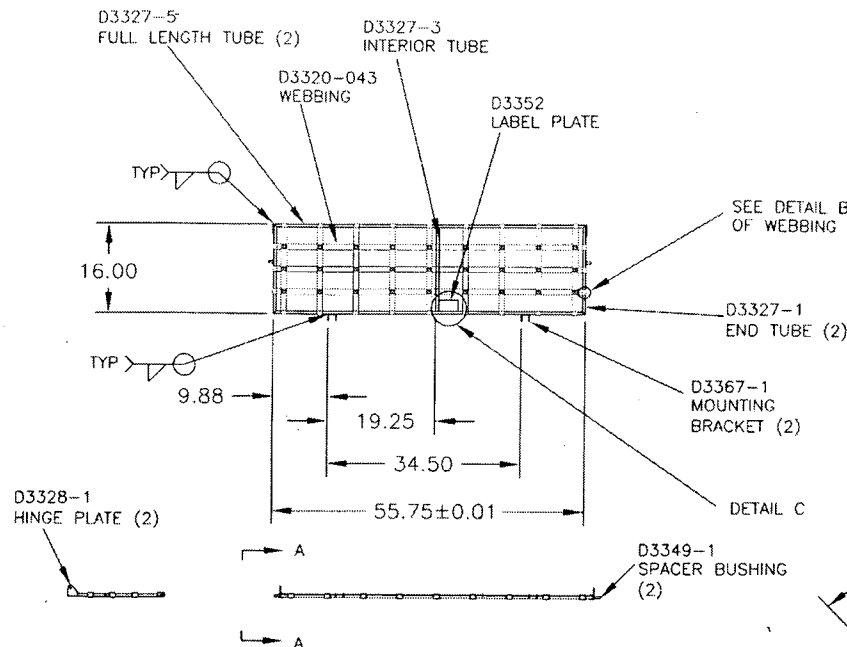
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SHOP COPY

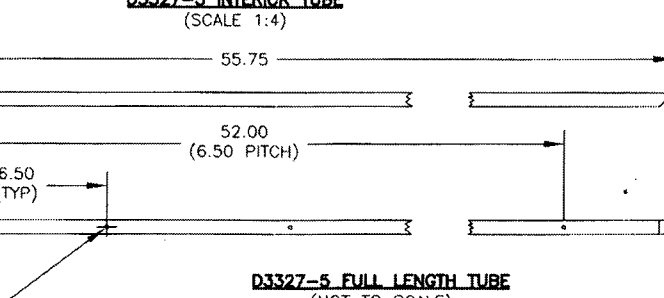
RETURN TO

ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82733 MLC
12/04/05



D3327-1 END TUBE
(SCALE 1:4)

D3327-3 INTERIOR TUBE
(SCALE 1:4)



D3327-5 FULL LENGTH TUBE
(NOT TO SCALE)

D3327-1/-3/-5

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: 4130 COND. N SQ. TUBE, AMS-T-6736, 1/2" X 0.035 (REF. DART SPEC M4130N-TS0.500W.035)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

B	05.04.25	CHANGE RIVET AND HOLE DIAMETER
A	04.10.21	NEW ISSUE
DESIGN	DRAWN BY	DART
CHECKED	APPROVED	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
DATE	DRAWING NO.	REV. B
05.04.25	D3327	SHEET 1 OF 3
	TITLE	SCALE
	BASKET LID ASSEMBLY	1:20

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DEO ATTACHED

D3327-041 BASKET LID ASSEMBLY

- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3 (PRIOR TO INSTALLATION OF D3320-043)
- 2) WELD PER DART QSI 004
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

PARTS LIST FOR D3327-041 BASKET LID ASSEMBLY

Part No.	Quantity	Description
D2729-1	1	PART ID LABEL
D3320-043	1	WEBBING
D3327-1	2	END TUBE
D3327-3	1	INTERIOR TUBE
D3327-5	2	FULL LENGTH TUBE
D3328-1	2	HINGE PLATE
D3349-1	2	SPACER BUSHING
D3351-1	1	PLACARD
D3352-1	1	LABEL PLATE
D3367-1	2	MOUNTING BRACKET
MS20600AD4W3	24	RIVET
AN960JD9	24	WASHER

RELEASED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

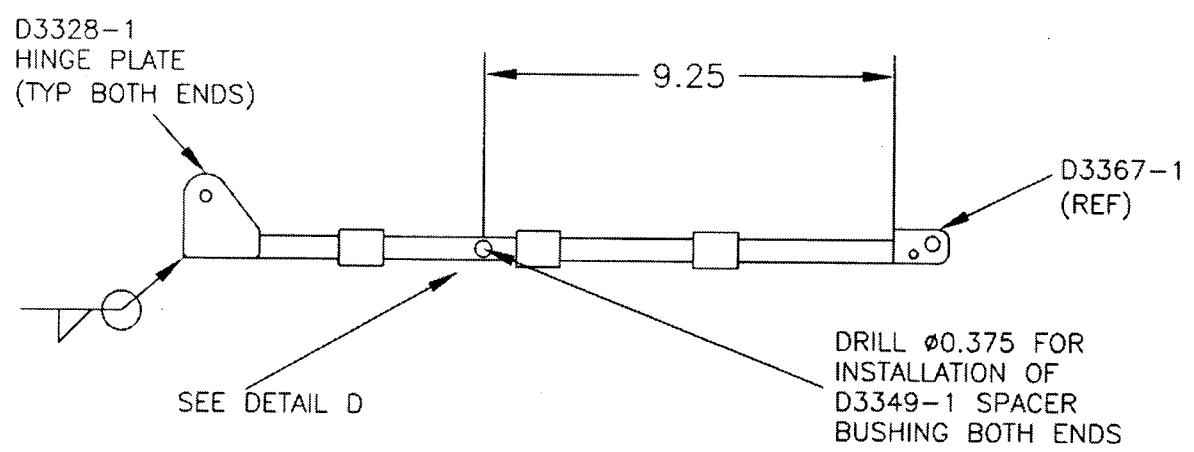
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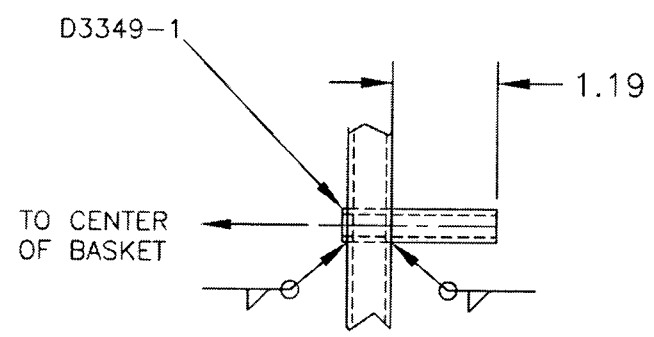
82733



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3327	REV. B SHEET 2 OF 3
DATE 05.04.25		TITLE BASKET LID ASSEMBLY	SCALE 1:4



VIEW A-A



DETAIL D
(SCALE 1:2)

DEO ATTACHED
RELEASED
05.04.28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

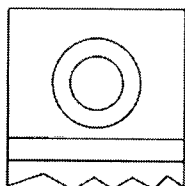
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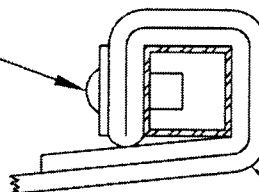
02720



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3327	REV. B SHEET 3 OF 3
DATE 05.04.25	TITLE BASKET LID ASSEMBLY		SCALE 1:4



MS20600AD4W3 RIVET (1)
AN960JD9 WASHER (1)



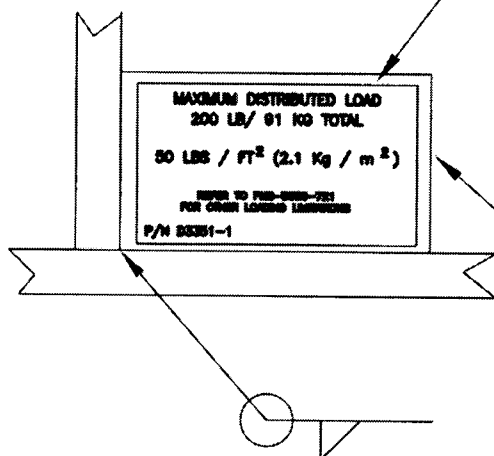
DETAIL B
TYP. ATTACHMENT OF WEBBING TO LID
FRAME
(SCALE 1:1)

D3320-043 WEBBING

RELEASED
05.04.28

DEO ATTACHED

ATTACH D3351-1 PLACARD
ON TOPSIDE OF D3352-1



D3352-1

OUTBOARD

IDENTIFY WITH DART P/N
D350-721-043 USING
D2729-1 PRODUCT ID LABEL
INSTALLED ON UNDERSIDE OF
D3352-1

DETAIL C
LABEL PLATE ATTACHMENT
(SCALE 1:2)

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82733

DRAWING NO. D3327	TITLE BASKET LID ASSEMBLY	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3327-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 08.11.28	DATE 08.11.28	DATE 08.12.01	DATE 08.12.01		DATE 08.12.01		

1) SHEET 1 MODIFY PARTS LIST AS SHOWN:

PART LIST FOR D3327-041 BASKET LID ASSEMBLY

Part No.	Quantity	Description

IS:

MS20600AD4W5	24	RIVET
--------------	----	-------

WAS:

MS20600AD4W3	24	RIVET
--------------	----	-------

2) UPDATE SHEET 3 DETAIL B ACCORDINGLY.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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